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DART AEROSPACE LTD	Work Order:	21581
Description: Bearpaw Kit (19" x 24")	Part Number:	K10008
Dwg: D2432 Rev. F3	Qty:	20 Kits
Ref: K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required	<i>[Signature]</i>	04.09.23	20																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 (Bag Bluefiles separately)	<i>WK 42 [Signature]</i> <i>[Signature]</i> <i>PH</i>	04.10.12	20																																																
3	GA	Cut 2 blanks per (1) K10008 Kit Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: <u>M15411</u>	<i>mk</i>	04/10/20	20																																																
4	MV	Inspect material for defects or damage prior to machining	<i>mk</i>	04/10/20	20																																																
5	MV	Machine as per Folio D2432 and Dwg D2432 Identify as D2432F	<i>mk</i>	04/10/20	20																																																
6	QC2	Inspect parts as they come off the CNC machine	<i>mk</i>	04/10/20	20																																																
7	MV	Deburr	<i>mk</i>	04/10/20	20																																																
8	QC8 & 5	Second inspection	<i>EP</i>	04/10/20	20																																																
9	KP	Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B21185</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B21188</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B21581</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B21189/B20963B</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B20964B/B20388</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B20433</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>m15321/m14544</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>m14526/m14311</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>m15020/m15321</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m15020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B21185	12	D2274	Radius Block	B21188	2	D2432F	24" Bearpaw	B21581	6	D2438	Clamp	B21189/B20963B	12	D2529	Washer	B20964B/B20388	6	D2732-050	Rubber Cushion	B20433	12	AN4-15A	Bolt	m15321/m14544	12	AN4-17A	Bolt	m14526/m14311	24	AN960JD416	Washer	m15020/m15321	12	MS21042L4	Nut (or -4)	m15020	1	Paperwork package from Step 2			<i>CL</i>	04/10/21	20
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10	QC4	Inspect Kit for 100% Completeness on the W/O	<i>[Signature]</i>	04/10/26	20																																																
11	PK	Identify and pack for shipping as per PPP K10008 <i>Rw: E</i>	<i>[Signature]</i>	04-10-26	20																																																
12	AC	Cost / part <u>218.49</u>	<i>54C</i>	04.10.27	20																																																
13	DC	Close W/O <u>218.51</u> Inspect Level 21	<i>[Signature]</i>	04.10.27	20																																																

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	

BS 04-10-27

RELEASED
04.02.20

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	21581
Description: Bearpaw		Part Number:	D2432F
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060x45°	✓		Vern	
B	5.500	+/-0.030	5.505	✓		Vern	
C	0.200	+/-0.030	0.202	✓		Vern	
D	0.25 x 45°	+/-0.030	0.235x45°	✓		Vern	
E	R0.250	+/-0.030	R0.250	✓		R-G	
F	0.250	+/-0.010	0.256	✓		Vern	
G	0.625	+/-0.030	0.633	✓		Vern	
H	0.375	+/-0.010	0.383	✓		Vern	
I	0.950	+0.030/0.010	0.946	✓		Vern	
J	19.000	+/-0.030	19.000	✓		M-Tape	
K	3.14	+/-0.030	3.110	✓		Vern	
L	3.28	+/-0.030	3.289	✓		Vern	
M	Ø0.260	+0.005/-0.000	Ø0.260	✓		Vern	
N	Ø0.93	+/-0.030	Ø0.927	✓		Vern	
O	0.30	+0.030/-0.000	0.310	✓		Vern	
P	23.750	+/-0.030	23.750	✓		M-Tape	
Q	7.375	+/-0.030	7.375	✓		M-Tape	
R	4.250	+/-0.010	4.250	✓		Vern	
S	2.000	+/-0.030	2.000	✓		Vern	
T	9.000	+/-0.010	9.000	✓		M-Tape	
U	9.000	+/-0.010	9.000	✓		M-Tape	
V	0.375	+/-0.010	0.380	✓		Vern	

Measured by: <i>ml</i>	Audited by: <i>CE</i>	Prototype Approval:	N/A
Date: 04/10/20	Date: 04.10.20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	<i>[Signature]</i>

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 23, 2004
10:35 am

Work Order No : 0021581
Project Name : K10008
Project For : WK444
Work Order Type : Main
Main WO Number :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced

House Part Number : *K10008
Description : Bearpaw kit 19" x 24"
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0

Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Start Date : 09-23-04
Est Finish Date : 10-30-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00